

Work Order ID 79423

79423

Page 1

January-26-12 8:07:41 AM

Item ID: D2574 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Aft In 205
 Start Date: 26/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 15/02/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/26 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2574	Rev E								

100 0.00
100 HAAS CNC VERTICAL MACHINING #1
 HAAS I Memo 0.00
 HAAS CNC vertical machine #1 Program Batch No. 79423 Double check by: Ra 1-Machine Step
 No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine
 Step No 2 per Folio FA051 and inspect per attached Dimension Sheets3-
 Machine Step No 3 per Folio FA051 and insp

110 0.00
110 CONVENTIONAL MILLING MACHINE
 Mill Conv Memo 0.00
 Conventional Milling Machine Machine keyway as per dwg D2573 & D2574

120 0.00
120 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79423

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79423

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Item ID: D2574 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Aft In 205
 Start Date: 26/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 15/02/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		B.A 12/02/02		12	0		
--	---	------------------	--	--------------	--	----	---	--	--

140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				12	12	12	
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150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 8:20 FINISH TIME: 8:50	0.00 0.00							
---	---	------------------	--	--	--	--	--	--	--

12 X 8 M - 12/02/03

M 119480

3200 F

8:50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 79423

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Page 3

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Item ID: D2574 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Aft In 205
Start Date: 26/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 15/02/2012 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160 QC3- Inspect Part Finish 0.00

160

QC

Memo

0.00

Quality Control

12/2/12

170 Identify as per dwg & Stock Location: 437 0.00

170

Packaging

Memo

0.00

Packaging

12/2/12

180 QC21- Final Inspection - Work Order Release 0.00

180

QC

Memo

0.00

Quality Control

12/2/12

12/2/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-26-12 8:07:45 AM

Page 1

Work Order ID: 79423

79423

Parent Item: D2574

D2574

Parent Item Name: Saddle, Aft In 205

Start Date: 26/01/2012

Required Date: 15/02/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-005		Manufactured	No			110	Each	32.0000	1	12			
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D6101-005

Saddle Billet

**

29 12.1.27

Location

Loc Qty

Loc Code

MAT041

28

71721

1

76838

27

MAT045

1

74507

1

MAT046

3

66966

3

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	79423
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.003	8.003	8.003		
F	0.490	0.510		.502	.502	.502	.502		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.501	.501	.501	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.126	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.253	.253	.253	.253		
S	0.115	0.135		.130	.130	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.244	.244	.244	.244		
W	0.115	0.135		.131	.131	.129	.131		
X	0.307	0.312		.309	.310	.310	.310		
Y	0.760	0.765		.762	.762	.762	.762		
Z	0.352	0.372		.370	.370	.370	.370		
AA	0.470	0.530		.50	.50	.50	.50		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.511	1.511	1.511	1.511		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.275	.275	.275	.275		
AH	0.240	0.260		.255	.255	.255	.255		
AI	2.000	2.020		2.001	2.001	2.001	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	RF
Date:	12.1.80

Audited by:	B.A
Date:	12/02/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				440 128 568		438 4 15 200 219 283 502	376 35 358 18 3101
				438 106 4 15 219 406 625			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 79 423
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	A5	A6	A7	A8	By	Date
A	0.438	0.443		.438	.438	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		.501	.502	.500	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.126	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.257	.257		
S	0.115	0.135		.129	.129	.129	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.226	3.226	3.226	3.226		
V	0.230	0.250		.242	.242	.242	.242		
W	0.115	0.135		.131	.128	.131	.130		
X	0.307	0.312		.309	.310	.309	.309		
Y	0.760	0.765		.763	.762	.762	.762		
Z	0.352	0.372		.368	.368	.368	.369		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.624	.624	.624		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.248	.249	.249		
AE	1.500	1.520		1.511	1.512	1.512	1.5095		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.275	.275	.275	.275		
AH	0.240	0.260		.251	.252	.252	.252		
AI	2.000	2.020		2.001	2.002	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	cmf
Date:	12/01/31

Audited by:	B.A
Date:	12/02/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 79423
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	19	210	811	412	By	Date
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.502	.502	.501	.503		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.567	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.257	.252	.252	.252		
S	0.115	0.135		.128	.129	.129	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.227	3.226	3.226	3.226		
V	0.230	0.250		.240	.240	.241	.240		
W	0.115	0.135		.127	.127	.128	.126		
X	0.307	0.312		.309	.309	.309	.309		
Y	0.760	0.765		.763	.762	.762	.762		
Z	0.352	0.372		.366	.366	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.625	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.247	.248	.249		
AE	1.500	1.520		1.5115	1.5112	1.5122	1.5116		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.275	.275	.275	.275		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.003	2.003	2.0034	2.0035		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

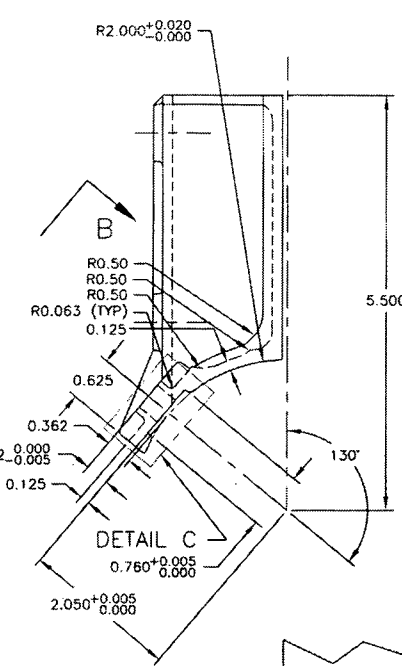
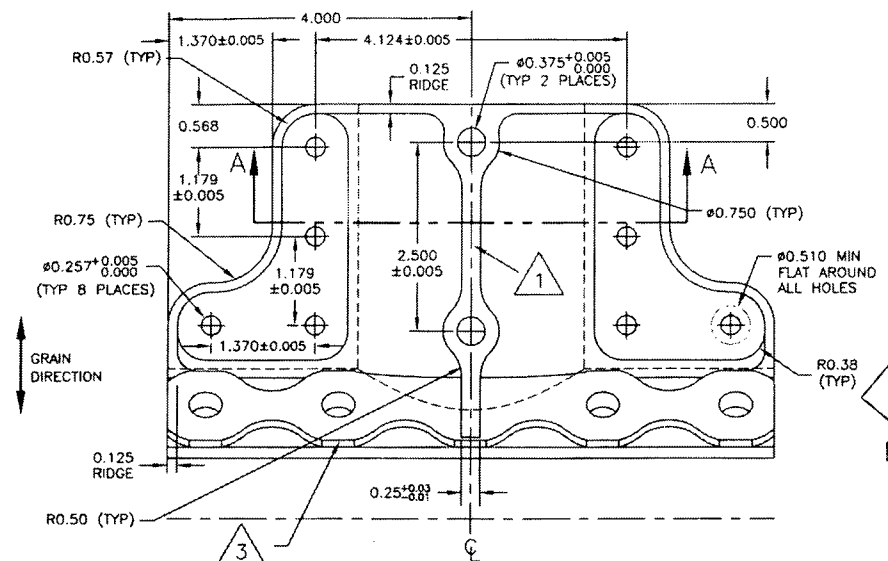
Measured by:	grl
Date:	12/01/31

Audited by:	Ma
Date:	12/02/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

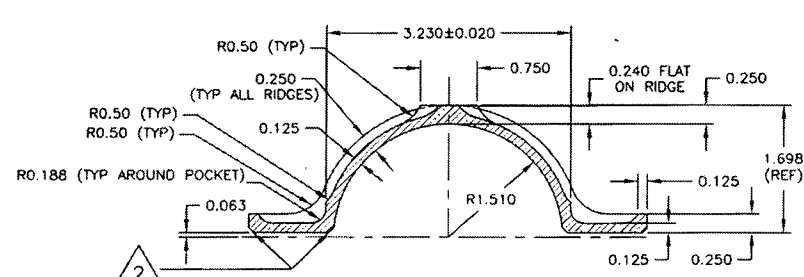
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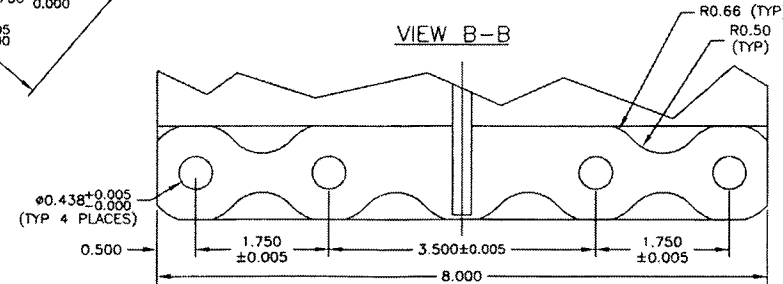
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

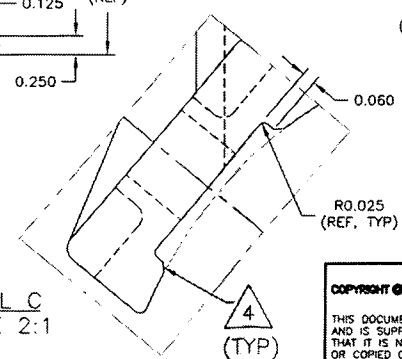
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



SECTION A-A



VIEW B-B



DETAIL C
SCALE 2:1

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DESIGN	DS	DRAWN BY	PH	DART	DART AEROSPACE LTD. HUNTSBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	D2574
DATE	05.07.13	TITLE	INNER AFT SADDLE	REV. E	SHEET 1 OF 1
		SCALE	2:1		

UNCONTROLLED

SUBJECT TO APPROVAL

WITHOUT NOTICE
WORK ORDER

NO 79423M.C.J
12/01/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries